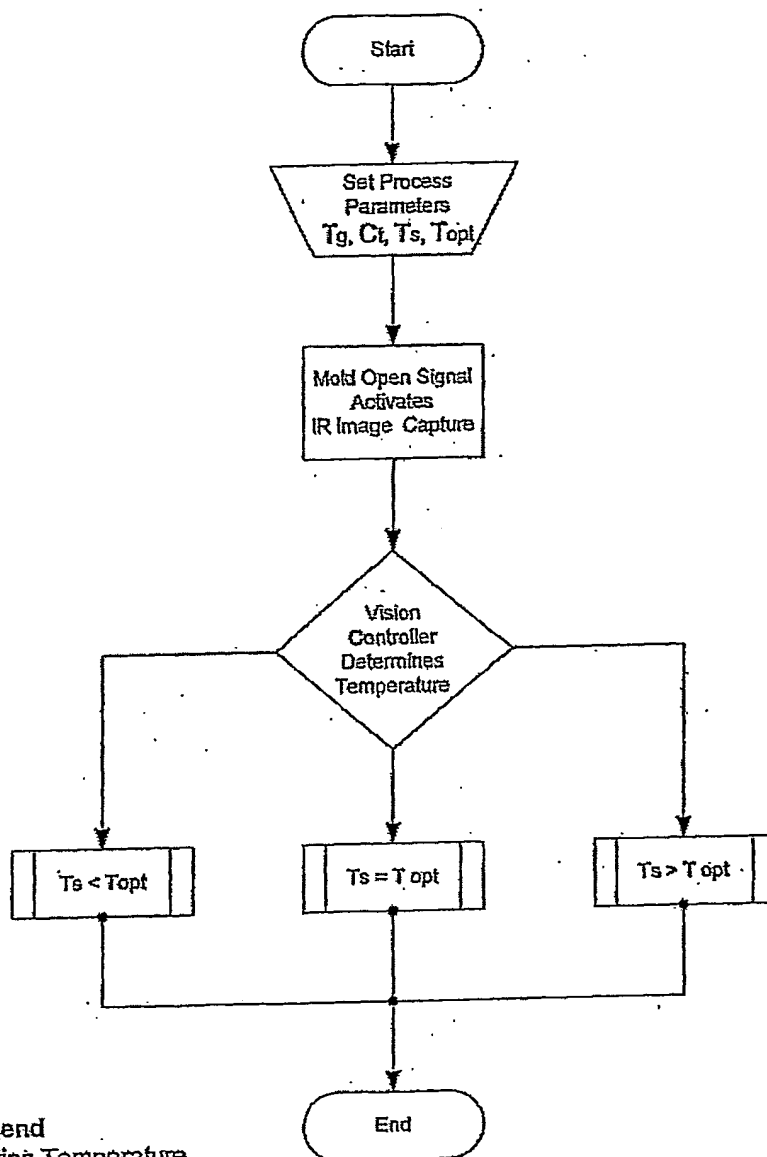


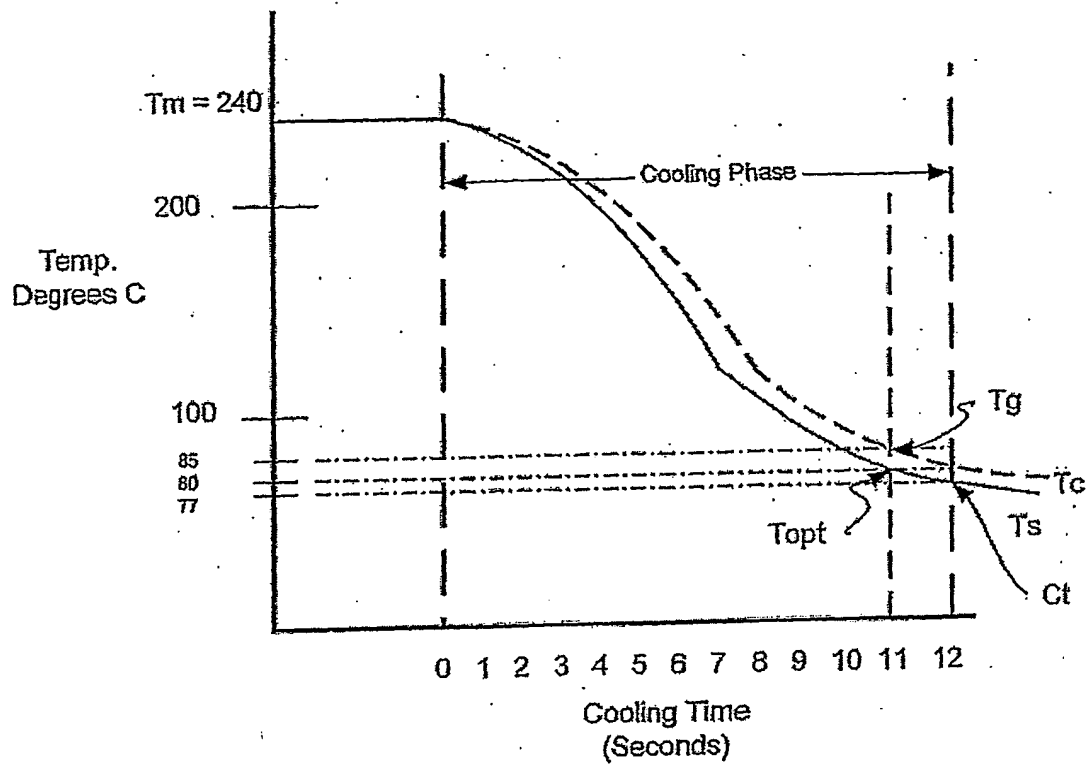
FIG. 1

Fig. 4

**Legend**

T_g = Glass Transition Temperature
 T_s = Outside Surface Temperature
 T_{opt} = Optimum Ejection Temperature
 C_t = Cooling Time

Fig 5



Legend

- T_m = Melt Temperature
- T_c = Part Center Temperature
- T_g = Glass Transition Temperature
- T_s = Outside Surface Temperature
- T_{opt} = Optimum Ejection Temperature
- Ct = Cooling Time

FIG 2

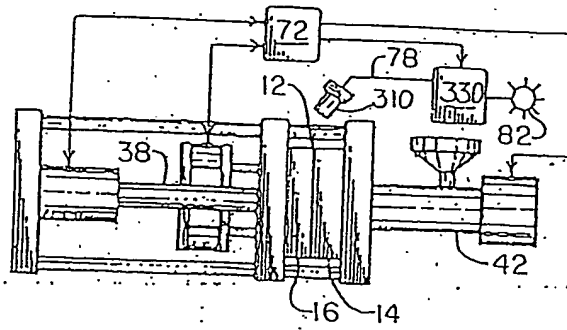


FIG 3

